

Work Order ID 128635

January-20-15 11:06:10 AM

128635

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Item ID: D2199-9 Accept *N9000040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Strut Details
 Start Date: 1/20/15 Start Qty: 2.00 *2* Cust Item ID:
 Required Date: 1/21/15 Req'd Qty: 2.00 *2* Customer:
 Reference:

Approvals: Process Plan: W Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2199	Rev E1

100	NC BRAKE	0.00				2	FF	JAN 20 2015
100								
Brake NC	Memo	0.00						
Brake NC	Punch per Dwg. D2199 and Spec Control Dwg D2638							

110	Small Fab	0.00				2	FF	JAN 20 2015
110								
Small Fab	Memo	0.00						
Small Fab	Debur							

120	QC5- Inspect part completeness to step on W/O	0.00				2		
120								
QC	Memo	0.00						
Quality Control								

DAS
38
9-89

JAN 20 2015

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130 *130* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.2) per OSI005 4.3-Steel <i>M 124808</i> Memo START TIME: <i>9:10</i> FINISH TIME: <i>9:40</i> OVEN TEMPERATURE: <i>700</i>	0.00				<i>2</i>	<i>0</i>	<i>15-1-21</i>	<i>858</i>
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140 *140* QC Quality Control	QC3- Inspect Part Finish Memo	0.00				<i>(2)</i>			DAS 38 9-89 JAN 21 2015
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150 *150* Packaging Packaging	Identify as per dwg & Stock Location: <i>St 352</i> Memo	0.00							DAS 85 9-89 JAN 21 2015
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 Required Date: 1/21/15 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

MLJ 1501-22
ME
15-1-21

Picklist Print

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Parent Item: D2199-9

D2199-9

Parent Item Name: Strut Details

Start Date: 1/20/15

Required Date: 1/21/15

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP: A02.06.10New IssueNG/RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304TR0.750W.049

Purchased

No

110

f

231.6000

1.4

3

M304TR0 750W 049

FF

JAN 20 2015

304 RD Tube .750 x .049W

Location

Loc Qty

Loc Code

GA002

231.6

M128084

4

M129363

73.6

M130292

154

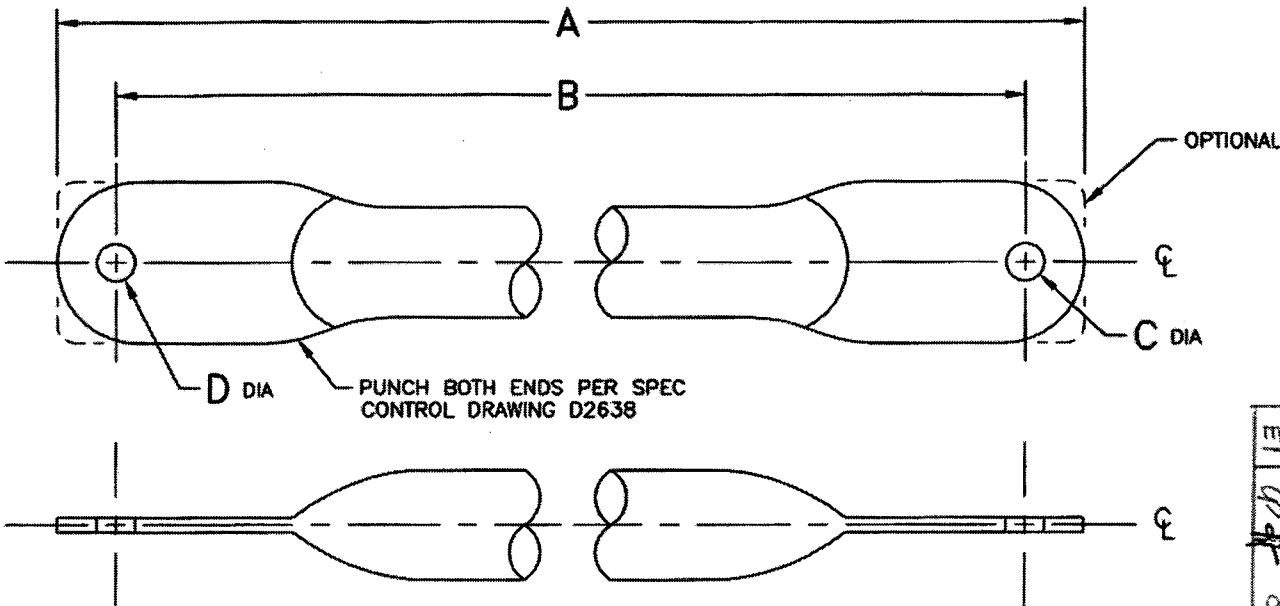
1.5
1.5



RELEASED
98.05.05 KE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. E
DATE		D2199	SHEET 1 OF 1
98.04.28		TITLE	SCALE
		STRUT DETAILS	NTS

A	1993	NEW ISSUE
B		ADDED -11, -13, AND -15
C		ADDED -17 AND -19
D		ADDED -21
E	98.04.28	ADDED -23 AND -25 PER TSR A565M ADDED TEMPLATE & SPEC CTRL DWG REDRAWN IN CAD
E1	98.05.22	ADD FINISH



	A	B	C	D
D2199-1	18.30	17.50	0.257	0.257
D2199-3	5.80	5.00	0.257	0.257
D2199-5	22.64	21.84	0.257	0.316
D2199-7	14.74	13.94	0.257	0.257
D2199-9	16.52	15.72	0.257	0.257
D2199-11	23.60	22.80	0.257	0.316
D2199-13	15.96	15.16	0.257	0.257
D2199-15	17.57	16.77	0.257	0.257
D2199-17	28.05	27.25	0.257	0.316
D2199-19	18.90	18.10	0.257	0.257
D2199-21	10.80	10.00	0.257	0.257
D2199-23	26.18	25.38	0.257	0.316
D2199-25	19.93	19.13	0.257	0.257
D2199-27	27.34	26.54	0.257	0.316
D2199-29	21.11	20.31	0.257	0.257

W/O 128635
#00.10.13
#00.10.13

- NOTES:
1. MAKE PER TEMPLATE DT2199-XX WHERE XX IS THE RESPECTIVE DASH NUMBER
 2. MATERIAL: AISI 304/316 STAINLESS STEEL TUBE Ø0.750 x 0.049 WALL
 3. FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3/E1

FIRST ARTICLE INSPECTION CHECKLIST

Measured by: FF	Audited by: 9-89	Preliminary Approval:
Date: JAN 20 2015	Date: 15/01/20	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15